

Work Order ID 153108

Tuesday, November 08, 2016 10:52:30 AM

153108

Page 1

Item ID: D4440-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Grommet
 Start Date: 11/24/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 11/29/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: NOV 09 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4440	A

100		0.00							<u>DAS 13 9-89</u>
-----	--	------	--	--	--	--	--	--	--------------------

100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 34333
 Supplier P#: GRD21625375PA
 Possible supplier: Essentra Component
 Material release note is required.

20 NOV 16 2016

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

110
 Packaging
 Packaging
 Memo
 0.07

20 NOV 24 2016 DAS 6 9-89

120	QC6- Inspect dimensions to drawing	0.00							
-----	------------------------------------	------	--	--	--	--	--	--	--

120
 QC
 Quality Control
 Memo
 0.00

20 NOV 25 2016 DAS 38 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment	☐	☐ No Re-verification	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐ Operator	Bending	☐	Set-up	☐	Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐ Offset/Setup	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐ Supplier	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐ Part Incorrect
Handling/Pre	☐	☐ Training	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐ Use for Testing	Cuffs	☐	Contamination	☐	Out of Sequence	☐ Part Moved
Internal Transport	☐	☐ Poor Information	Crushing	☐	Countersink	☐	Off-set	☐ Drawing
Tribal Knowledge	☐	☐ Rushing	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐ Finish
LOA	☐	☐ Product Improvement	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐ Misread
Substation	☐	☐ Process Improvement	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐ Manufacturing Process	OTHER : _____					
Misidentified	☐	☐ Past Due						

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.03				<u>20</u>	<u>NOV 25 2016</u>		<u>DAS 6 9-89</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.33							
Quality Control									

16/11/28 JA

DAS
21
9-89

NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Tuesday, November 08, 2016 10:52:30 AM

Page 1

Required Qty: 20.00

DAS
6
9-89

Diaphragm Grommet

DQA: _____ Date: _____

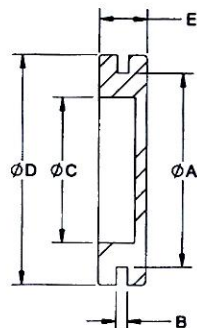


WORK ORDER NON-CONFORMANCE / UPDATE

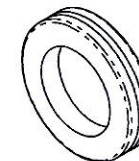
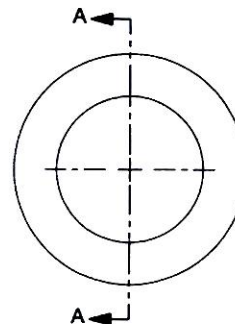
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153108 M.C.J

16-11-09

D4440-X GROMMET

DART PART NUMBER	DESCRIPTION	SUPPLIER PART NUMBER	STYLE NUMBER	SUPPLIER	MATERIAL	COLOR	A	B	C	D	E
D4440-1	GROMMET	GRD21625375PA	2	ALLIANCE	PVC (54-62 Shore A) or TPR (55 Shore A)	BLACK	1.63	0.094	1.22	1.93	0.4

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A lbs

RELEASED
2012-07-23

A		NEW ISSUE		RF	12.01.17
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4440	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR.		GROMMET	NTS		
DATE	12.01.17				
COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34333**

Purchase Order Date 11/16/2016

PO Print Date 11/16/2016

Page Number 1 of 2

Order From :

VC-ESS001

ESSENTRA COMPONENTS
P.O. BOX 9900 T-9915
POSTAL STATION A
TORONTO, ONTARIO M5M 2J2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
NOV 16 2016

Contact Name

Vendor Phone

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	GRD21625375PA AS PER DWG D4440 REV. A B153108	Diaphragm Grommet	11/23/2016 No 11/23/2016		20.00 Each	\$2.41	\$48.18
Line Total:							\$48.18
2	KBP-504 AS PER DWG D3801 REV. B B153299	Hand Retractable Spring Plunger	11/23/2016 Yes 11/23/2016		12.00 Each	\$24.46	\$293.52
Line Total:							\$293.52

Note:

11/16/2016



ESSENTRA

COMPONENTS

Essentra Components
2538 Speers Road, Unit 7
Oakville, ON L6L 5K9
Phone: 905-825-0134
Fax: 905-825-2919
www.essentracomponents.com

Packing List

LOAD NUMBER 509016
SID/INV 1474779
CUSTOMER PO PO34333
ORDER NUMBER 2235270
CARRIER Fed Ex Ground
SHIP DATE 11/23/16

FOB DESCRIPTION COI

SOLD TO 422854

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

DELIVERY TO 422854

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

LINE NO	PART NO. DESCRIPTION	ORIGINAL QUANTITY	QUANTITY SHIPPED	CTNS	NET WEIGHT	TOTAL WEIGHT
1	GRD21625375PA DIAPHRAGM GROMMET:TPR BLACK 1.65" HOLE X 0.094" 1000 BOX Cust Order #: PO34333 Country Of Origin: UK	.020	.020	1	.22	27.22
2	KBP-504 3/8-24 NON-LOCKING SS PULL INDEXING PLUNGER Cust Order #: PO34333 Country Of Origin: DE	12.000	10.000	10	.47	1.47

16/11/24 SV

Certificate of Compliance

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Richard Queer
Quality Assurance Manager